

Work Order ID 72590

Wednesday, August 03, 2011 8:02:14 AM



Page 1

Item ID: D206-667-103TRN

Accept



Setup Start



Revision ID:

Item Name: Crosstube Turning DetailL

Stop



Start Date: 8/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/15/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-08-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D206-667-143

Rev C U/R

QC 11.6LS

100

0.00

DFB / 11/08/24
mm.L



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

1 Ø

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Blend-transition lines only, **do not sand whole tube**

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

110

QC1- Inspect dimensions to dimension sheet

0.00

DFB / 11/08/24
mm.L



QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 72590

Wednesday, August 03, 2011 8:02:14 AM



Page 2

Item ID: D206-667-103TRN

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Required Date: 8/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | | 0.00 | | | | | | | |
| | MORI SEIKI CNC LATHE LARGE | | | | | | | | |
| Mori Seiki | Memo | 0.00 | | | | | | | |
| Mori Seiki CNC Lathe Large | 1-Turn second side as per Folio FA087 | | | | | | | | |
| | 2-File down transition lines smooth. | | | | | | | | |
| | 3-Blend transition lines only, **do not sand whole tube**: | | | | | | | | |
| | *Use mill bastard file, brush file repeatedly with file card. | | | | | | | | |
| | *Do not use sandpaper coarser than 320 grit. | | | | | | | | |
| 130 | | 0.00 | | | | | | | |
| | QC1- Inspect dimensions to dimension sheet | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| | QC8- Inspect parts - second check | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DF2/ 11/08/24 1 0
mm.c

DF2/ 11/08/24 1 0
mm.c

4/1/DP 11-8-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 72590

Wednesday, August 03, 2011 8:02:14 AM



Page 3

Item ID: D206-667-103TRN

Accept



Setup Start



Revision ID:

Item Name: Crosstube Turning DetailL

Stop



Start Date: 8/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack Location: LG

JW 11-8-29
11-8-29
JW 11-8-29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 03, 2011 8:02:21 AM

Page 1

Work Order ID: 72590



Parent Item: D206-667-103TRN



Parent Item Name: Crosstube Turning DetailL


Start Date: 8/3/2011

Required Date: 8/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 removed polish EC verified by DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6002-115  Crosstube Material | | Manufactured | No | | | 110 | Each | 19.0000 | 1 | 1 | | | |

Location

Loc Qty

Loc Code

LG

19

34684

1

34776

18

9797.6 11/08/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

| | | |
|--|---------------------|--------------|
| DART AEROSPACE LTD | Work Order: | 72590 |
| Description: Crosstube Assembly (206L High Fwd) | Part Number: | D206-667-143 |
| Inspection Dwg: D206-667-143 Rev: C | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Inspection Sheet | Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------|-------------------|---------------|------------------|--------|--------|----------------------|----------------------|
| SIDE A | 2.240 | +0.005/-0.000 | 2.240" | ✓ | | Mic. | CNC-04 |
| | 1.982 | +0.005/-0.000 | 1.984" | ✓ | | Vern. | J-F-05 |
| | 2.019 | +0.005/-0.000 | 2.024" | ✓ | | Mic. | CNC-04 |
| | 2.058 | +0.005/-0.000 | 2.063" | ✓ | | " | " |
| | 2.097 | +0.005/-0.000 | 2.100" | ✓ | | " | " |
| | 2.136 | +0.005/-0.000 | 2.138" | ✓ | | " | " |
| | 2.176 | +0.005/-0.000 | 2.179" | ✓ | | " | " |
| | 2.201 | +0.005/-0.000 | 2.203" | ✓ | | " | " |
| | | | | | | | |
| | 0.125 | +/-0.010 | .125 | ✓ | | Vern. | MML-08 |
| | 0.400 x 30° | +/-0.010 | 0.400" | ✓ | | " | " |
| | R0.063 | +/-0.010 | .063 | ✓ | | R.G. | Ref. |
| | R0.500 | +/-0.010 | R0.500" | ✓ | | " | " |
| | 4.438 | +/-0.030 | 4.409" | ✓ | | Vern. | J-F-05 |
| | | | | | | | |
| SIDE B | 104.98 | +/-0.020 | 104.98 | ✓ | | tape | MML-02 |
| | 2.240 | +0.005/-0.000 | 2.243" | ✓ | | Mic. | CNC-04 |
| | 1.982 | +0.005/-0.000 | 1.985" | ✓ | | Vern. | J-F-05 |
| | 2.019 | +0.005/-0.000 | 2.024" | ✓ | | Mic. | CNC-04 |
| | 2.058 | +0.005/-0.000 | 2.063" | ✓ | | " | " |
| | 2.097 | +0.005/-0.000 | 2.100" | ✓ | | " | " |
| | 2.136 | +0.005/-0.000 | 2.138" | ✓ | | " | " |
| | 2.176 | +0.005/-0.000 | 2.178" | ✓ | | " | " |
| | 2.201 | +0.005/-0.000 | 2.203" | ✓ | | " | " |
| | | | | | | | |
| | 0.125 | +/-0.010 | .125 | ✓ | | AA Vern. | AA MML-08 |
| | 0.400 x 30° | +/-0.010 | 0.400" | ✓ | | " | " |
| | R0.063 | +/-0.010 | .063 | ✓ | | R.G. | Ref. |
| | R0.500 | +/-0.010 | R0.500" | ✓ | | " | " |
| | 4.438 | +/-0.030 | 4.423" | ✓ | | Vern. | J-F-05 |
| | | | | | | | |

| | | | |
|-------------------------------|---------------------------|------------------------------|-----|
| Measured by: MML/LP/18 | Audited by: DP/SLM | Preliminary Approval: | N/A |
| Date: 11/08/24 | Date: 11-8-25 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A | 04.05.06 | New Issue (P/O D206-667-103) | KJ/RF | |
| B | 06.03.09 | Dwg Rev updated | KJ/JLM | |
| C | 10.09.13 | Dwg Rev updated | KJ | AA |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

| Item | Qty -143 | Part Number | Description |
|------|-------------|----------------|--|
| 1 | X | D206-667-143 | CROSSTUBE ASSEMBLY (206L HIGH FWD) |
| 2 | 1 | D6002-115 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2891-1 | SUPPORT |
| 6 | 4 | D3595-063-395 | RUBBER CUSHION |
| 7 | 4 | MS21920-20 | CLAMP (OR MS21920-21) |
| 8 | 14 | MS20601AD4W8 | RIVET (OR NAS9302B-4-8) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 005. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO: 72590

600 #1-615
11.07.26

UNDER REVIEW

DEO ATTACHED RELEASED

| | | | |
|------------|--|--|----------|
| C | REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4. | RF | 08.11.06 |
| B | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES | PH | 05.07.26 |
| A | NEW ISSUE | CP | 00.11.17 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | DRAWING NO. REV. C D206-667-143 SHEET 1 OF 4 | |
| CHECKED | RF | TITLE SCALE CROSSTUBE ASSY (206L HIGH FWD) NTS | |
| MFG. APPR. | RF | DATE 08.11.06 | |
| APPROVED | RF | COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DE APPR. | RF | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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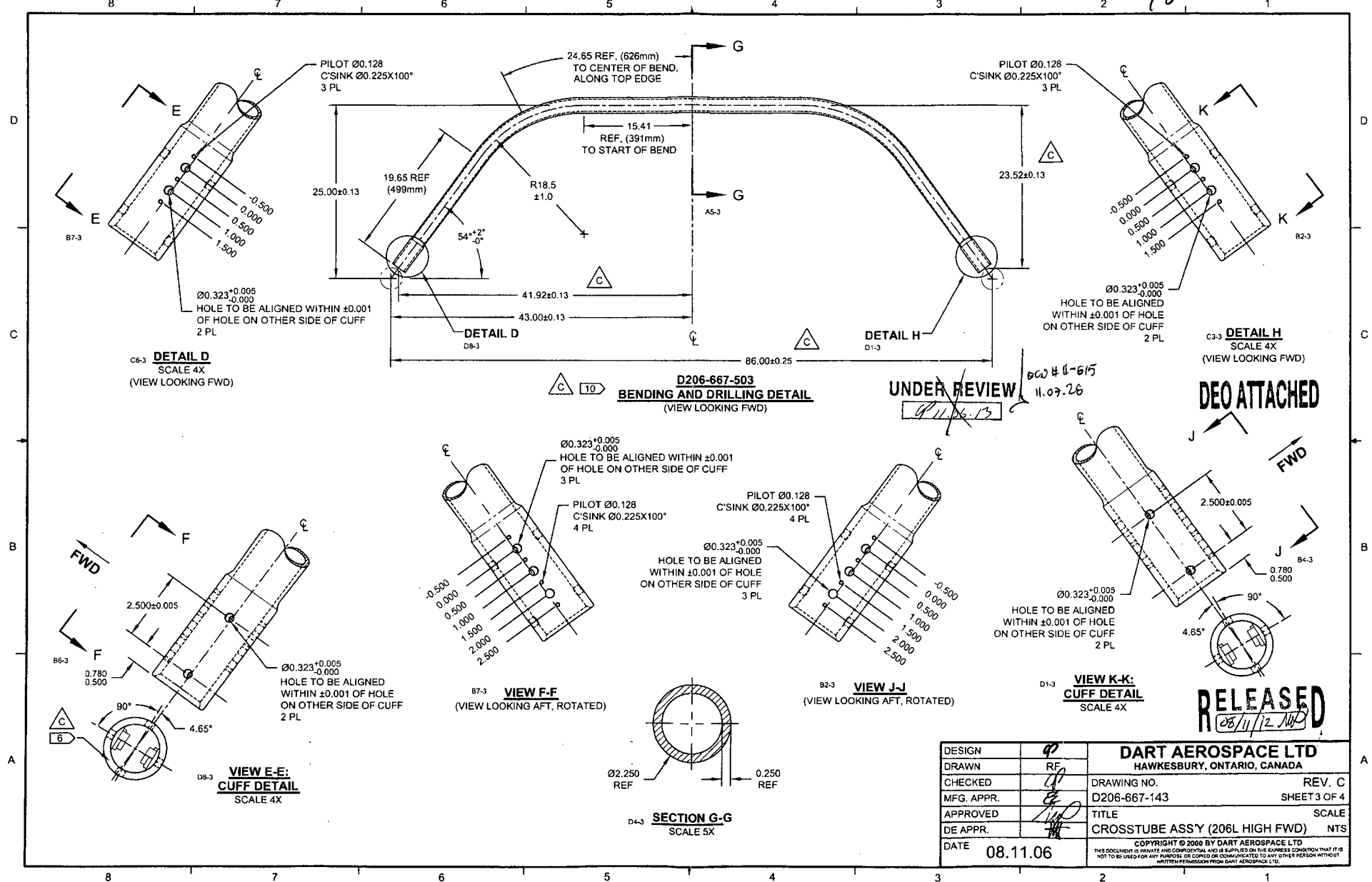
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NOTE: Date & initial all entries

72890



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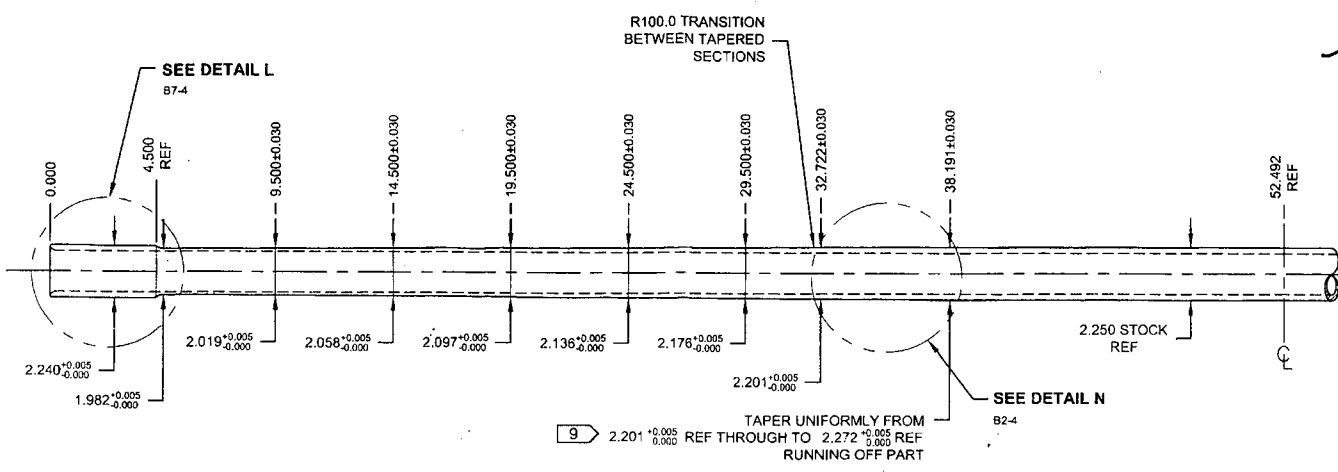
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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8 7 6 5 4 3 2 1

72590



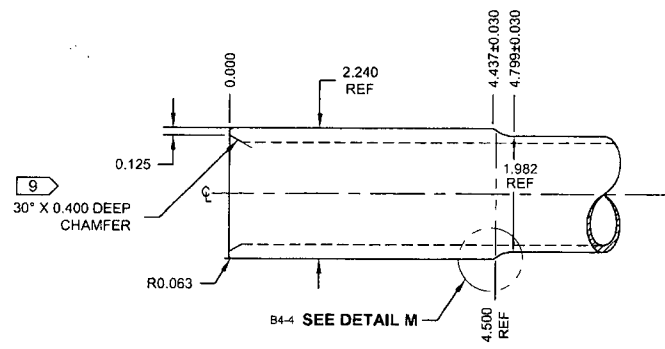
REC'D #11-615
11.07.26

UNDER REVIEW

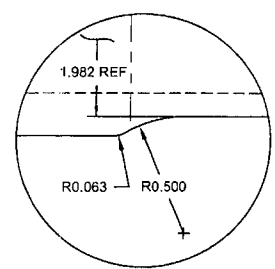
08/11/13

DEO ATTACHED

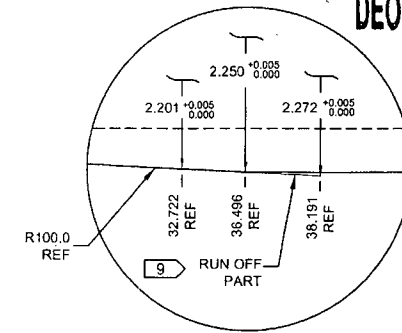
TURNING DETAIL



DETAIL L:
CROSSTUBE CUFF
NOT TO SCALE



DETAIL M:
CUFF TRANSITION
NOT TO SCALE



DETAIL N:
TAPER RUN-OFF
NOT TO SCALE

RELEASED
08/11/12

| | | | |
|--|----------|--|--------------|
| DESIGN | 97 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JP | DRAWING NO. | REV. C |
| MFG. APPR. | JP | D206-667-143 | SHEET 4 OF 4 |
| APPROVED | JP | TITLE | SCALE |
| DE APPR. | JP | CROSSTUBE ASSY (206L HIGH FWD) | NTS |
| DATE | 08.11.06 | COPYRIGHT © 2000 BY DART AEROSPACE LTD | |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |

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NOTE: Date & initial all entries

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|-----------------------------|--|---------------------------|---|--|--------------------------------|---------------------------|--------------|
| DRAWING NO. D206-667-143 | TITLE CROSSTUBE ASS'Y (206L HIGH FWD) | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D206-667-143-C-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN 97 | CHECKED ASS | MFG. APPR. [Signature] | APPROVED MD | | DE APPR. [Signature] | | |
| DATE 11.07.15 | DATE 11.07.20 | DATE 11.07.21 | DATE 11/07/21 | | DATE 11.07.21 | | |

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

| Item | Qty -143 | Part Number | Description |
|------|-------------|-----------------|-------------------------------|
| 9 | A/R | PROSEAL 890 B-2 | SEALANT, AMS-S-8802 CLASS B-2 |

WAS:

| | | | |
|---|-----|----------------|---|
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |
|---|-----|----------------|---|

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRAD E MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

7259d

RELEASED
2011-07-28
[Signature]

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries